

Date: Thursday, 3/30/2006 8:34:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 412 WEB
Job Number : 26440	
Estimate Number : 10466	
P.O. Number : N/A	Part Number : D33891
This Issue : 3/30/2006 S.O. No. : N/A	Drawing Number : D3389 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : C
Previous Run : 26439	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 4/20/2006 Qty: 1 Um: Each
Checked & Approved By : <u>06.03.30</u>	
Comment : Est Rev:A 05-08-31 New issue KJ/JLM	
Est Rev:B 06-02-08 As per Rev C JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D25003100	Ext'n -1' Beam Web 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ext'n -1' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
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1	D2500-3-100	Web Extrusion	
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B19674 Pm' 06-04-03 (1)

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389 Pm' 06-04-03 (1)

2-Drill pilot holes using DT8785 as per Dwg D3389 Pm' 06-04-03 (1)

3-Open 1X .257" Dia Hole Pm' 06-04-03 (1)

4-Open Remaining holes to finish size as per Dwg D3389 Pm' 06-04-03 (1)

5-Deburr Pm' 06-04-03 (1)

3.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

BE 06-04-03 (1)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M 06 04 03 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 20/04/10
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 412 WEB

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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/04/05 (1)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

46 DP06-4-6

(1)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/04/10 (1)

Job Completion



U 06/04/07

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

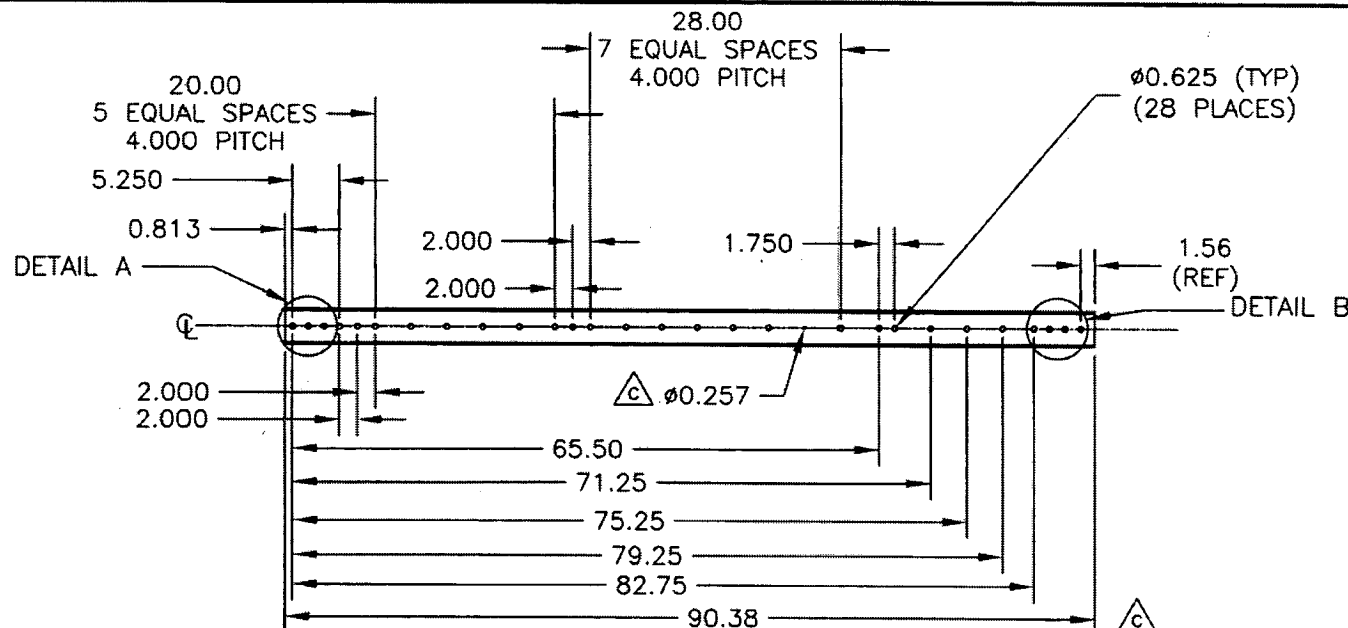
NOTE: Date & initial all entries



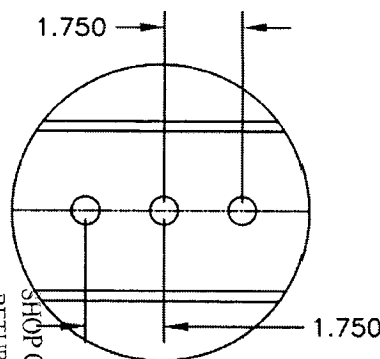
RELEASE

06.01.23

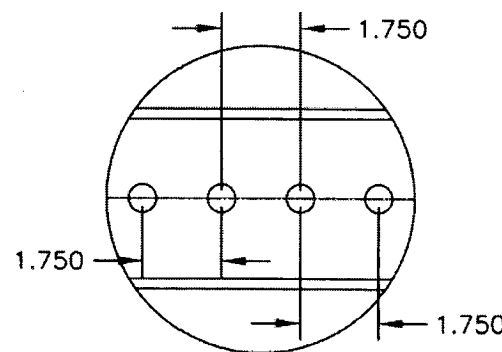
DESIGN	PH	DRAWN BY	PH	DART AEROSPACE USA, INC.	PORT HADLOCK, WA	REV. C
CHECKED		APPROVED		DRAWING NO.	D3389	SHEET 1 OF 1
DATE	06.01.23	TITLE	412 WEB	SCALE	1:20	
A	05.02.07	NEW ISSUE				
B	05.06.13	UPDATE DIMENSIONING				
C	06.01.23	DECREASE OVERALL LENGTH, MODIFY HOLE				



D3389-1 DRILLING DETAIL



DETAIL A
(SCALE 1:4)



DETAIL B
(SCALE 1:4)

D3389-1 412 WEB

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26440